

Date: Tuesday, 04/11/2008 11:19:26 AM  
User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPAD		
Job Number	: 43192					
Estimate Number	: 12785					
P.O. Number	:			Part Number	: D356411	
This Issue	: 04/11/2008		S.O. No. :	Drawing Number	: D3564 REV D	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type :	Drawing Revision	: D	
Previous Run	: 42248			Material	:	
Written By	:			Due Date	: 14/11/2008	
Checked & Approved By	: JLO 08.11.04			Qty:	12 Um: Each	
Comment	: Est Rev:A New Issue 07-03-08 ec Est Rev:B As per Rev C 07-07-09 JLM Est Rev:C As per Rev D 07-09-09 JLM Verified By:EC					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304S16GA	304/316 Sheet .063	
<b>Comment:</b> Qty.: 1.4805 sf(s)/Unit Total : 17.7660 sf(s) M304S16GA Stainless steel sheet 0.063" thick Batch: 109057 1B 8-11-11			
2.0	WATER JET	FLOW WATER JET	
<b>Comment:</b> FLOW WATER JET 1-Cut as per Dwg D3564 *****(D3564-1F)***** Dwg Rev: D 1B 8-11-11 Prog Rev: D			
<b>Comment:</b> 2-Deburr if necessary 1B 8-11-11			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
1B 8-11-11			
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE			
4.0	QC8	SECOND CHECK	
1/08.11.11 (12)			
<b>Comment:</b> SECOND CHECK			
5.0	BRAKE NC	NC BRAKE	
<b>Comment:</b> NC BRAKE Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT8179 and DT8155			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

S 08 u 14 (412)

7.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty	Description	Batch
A/R	2059B Hardcoat	M109893
Weld hardcoat as per Dwg D3437		

8.0 QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08 u 17 (X12)

9.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08 u 17 (X12)

10.0 POWDER COATING

POWDER COATING



M 106442

(12X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 12:45  
OVEN TEMPERATURE: 320°F  
FINISH TIME: 1:15

m/f 08/11/18

11.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Fx 08/11/18

(12)

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-19

Fx 08/11/19

(12)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: WEARPAD

Job Number: 43192

Part Number: D356411

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 QC21

FINAL INSPECTION/W/O RELEASE



08/11/19 JH

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

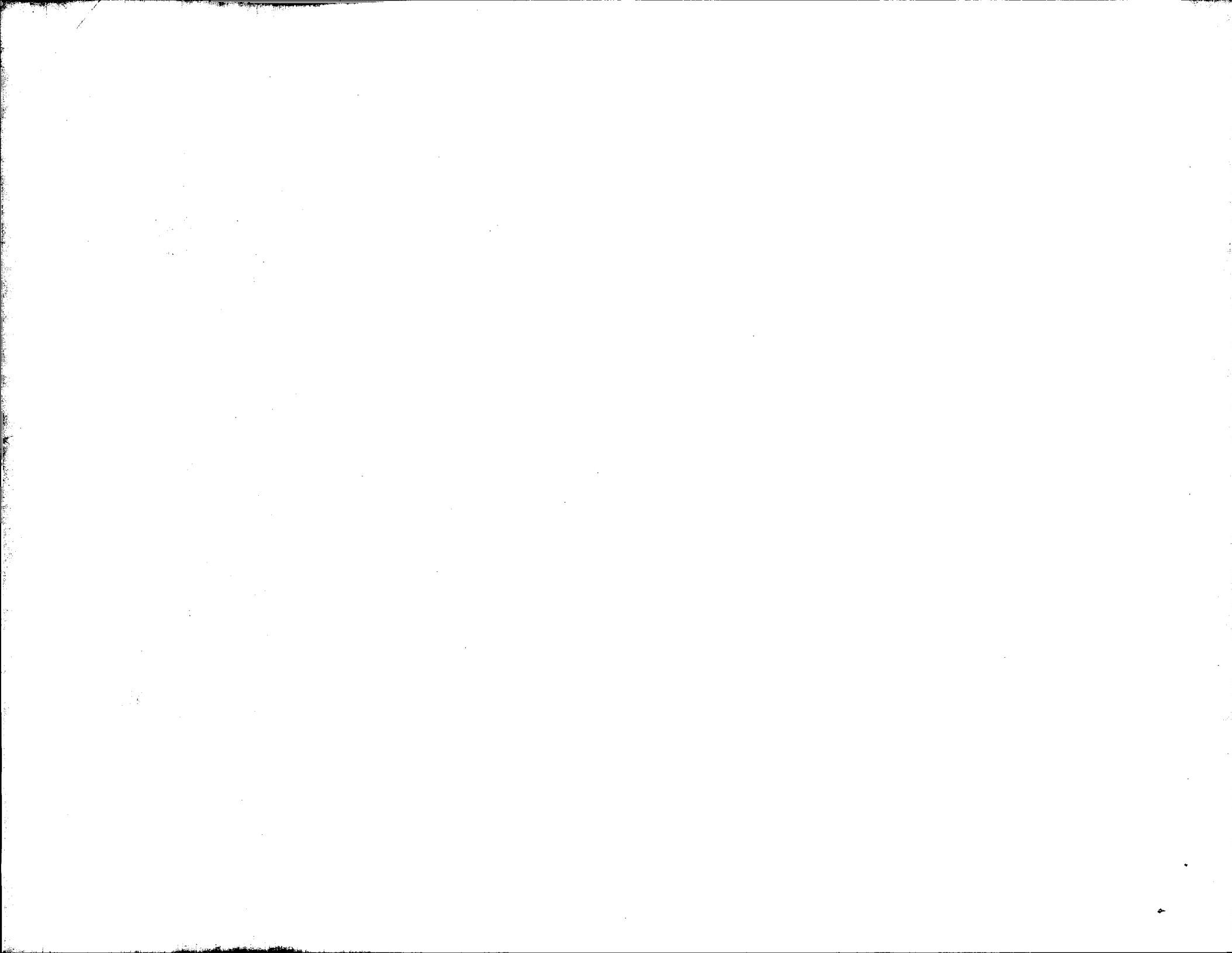
DART AEROSPACE LTD	Work Order:	H392
Description: Wearshoe	Part Number:	D3564-11
Inspection Dwg: D3564 Rev: D		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

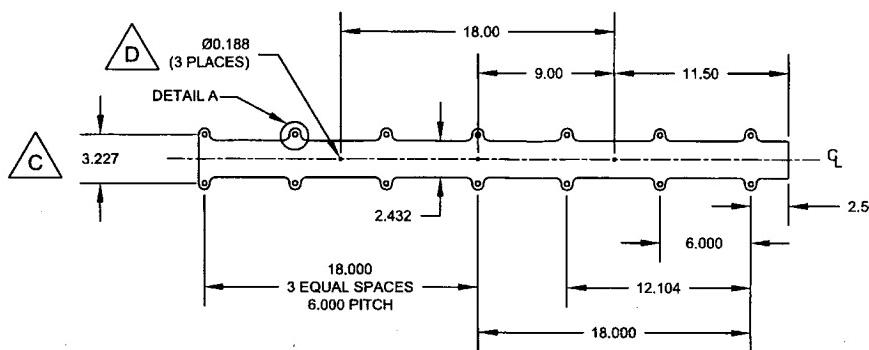
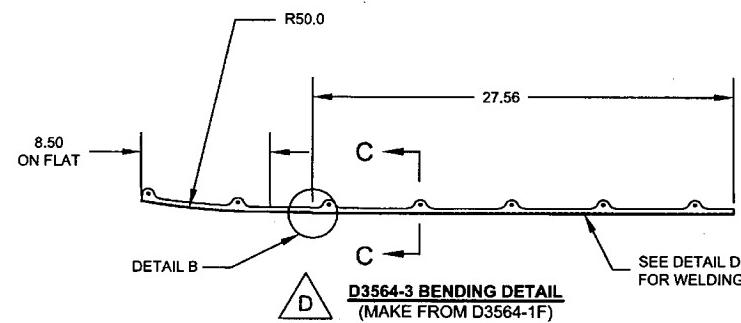
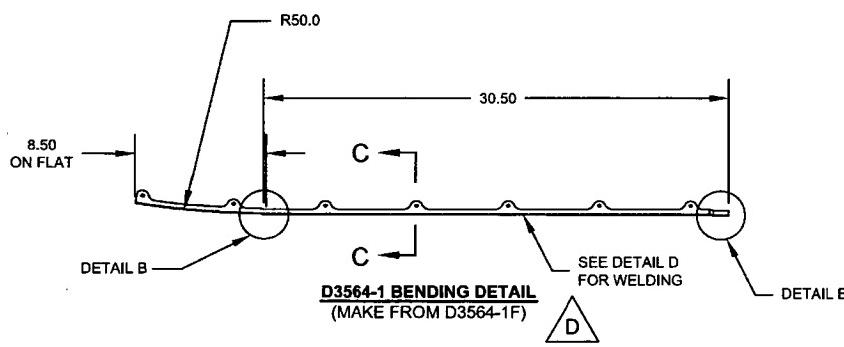
## X First Article      Prototype

Measured by:	<u>B</u>	Audited by:	<u>/</u>	Prototype Approval:	N/A
Date:	8-11-11	Date:	<u>06/11/11</u>	Date:	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	07.09.06	New Issue	KJ/JLM	
B	07.11.23	Dwg Rev updated	KJ/EC/DD	X



8 7 6 5 4 3 2 1

RELEASED  
07.09.04 #

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- D3564-1/-3/4/-7/-9/-11/-13/-15 WEARPLATE NOTES:
- MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK) (REF DART MATERIAL SPEC M304S16GA)
  - FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
  - TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - UNITS: INCHES UNLESS OTHERWISE NOTED
  - BREAK SHARP EDGES: 0.005 TO 0.015 MAX
  - IDENTIFICATION: NONE
  - WEIGHT: SEE TABLE IN ZONE A3
  - WELD PER DART QSI 004
  - SEE PG 3 FOR SECTIONS AND DETAILS
  - PARTS ARE SYMMETRIC ABOUT C

WEIGHTS:	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

REV.	DESCRIPTION	BY	DATE
D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8; PG3 B5,C5; ADD D3564-15; PG1 B6,B3; D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3; D3564-9/-11 WAS ONE FIGURE; PG2 A7,A3; D3564-9/-11 WAS ON PG1; PG3 B8,C8; D3564-13 WAS ON PG2; PG3 D2; WELDING DETAIL WAS ON PG1 PG3 A5.7,B2; RELOCATE DETAILS AND SECTION; PG3 A5.7,B2; INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
DESIGN	DRAWN	DART AEROSPACE LTD	
	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPR.	DRAWING NO.	REV. D
PH	SH	D3564	SHEET 1 OF 3
MFG. APPR.	APPROVED	TITLE	SCALE
	SH	WEARSHOE	1:8
DE APPR.	DATE	07.08.21	

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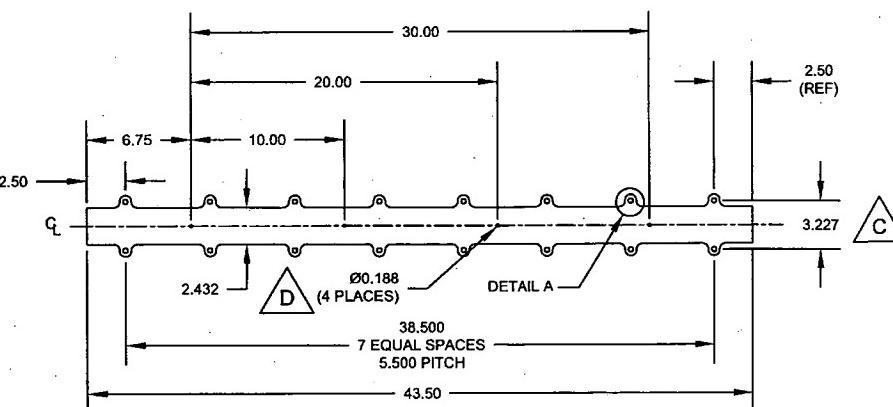
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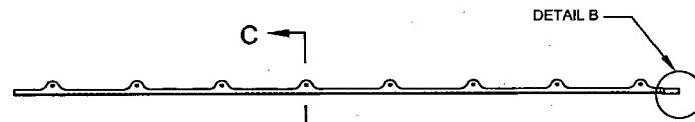
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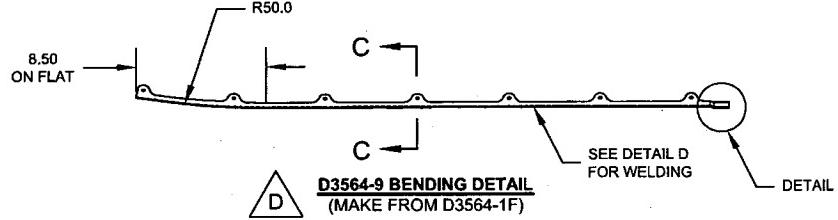
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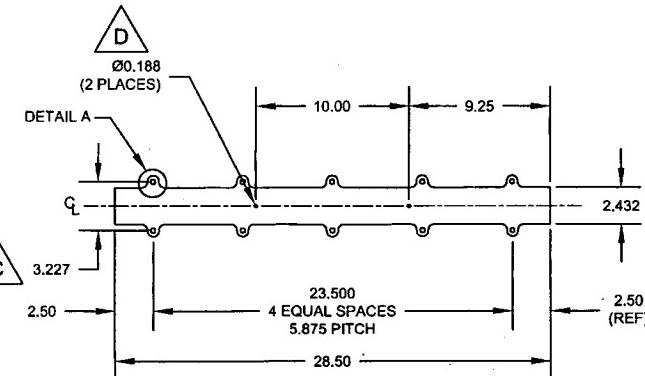
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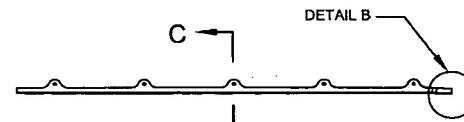
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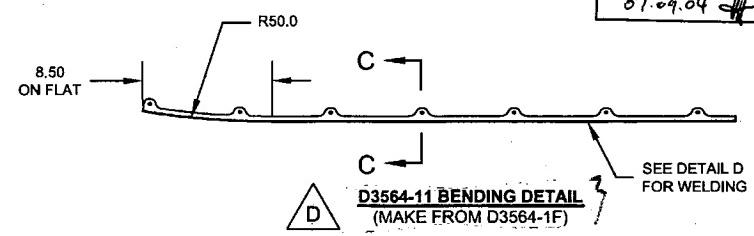
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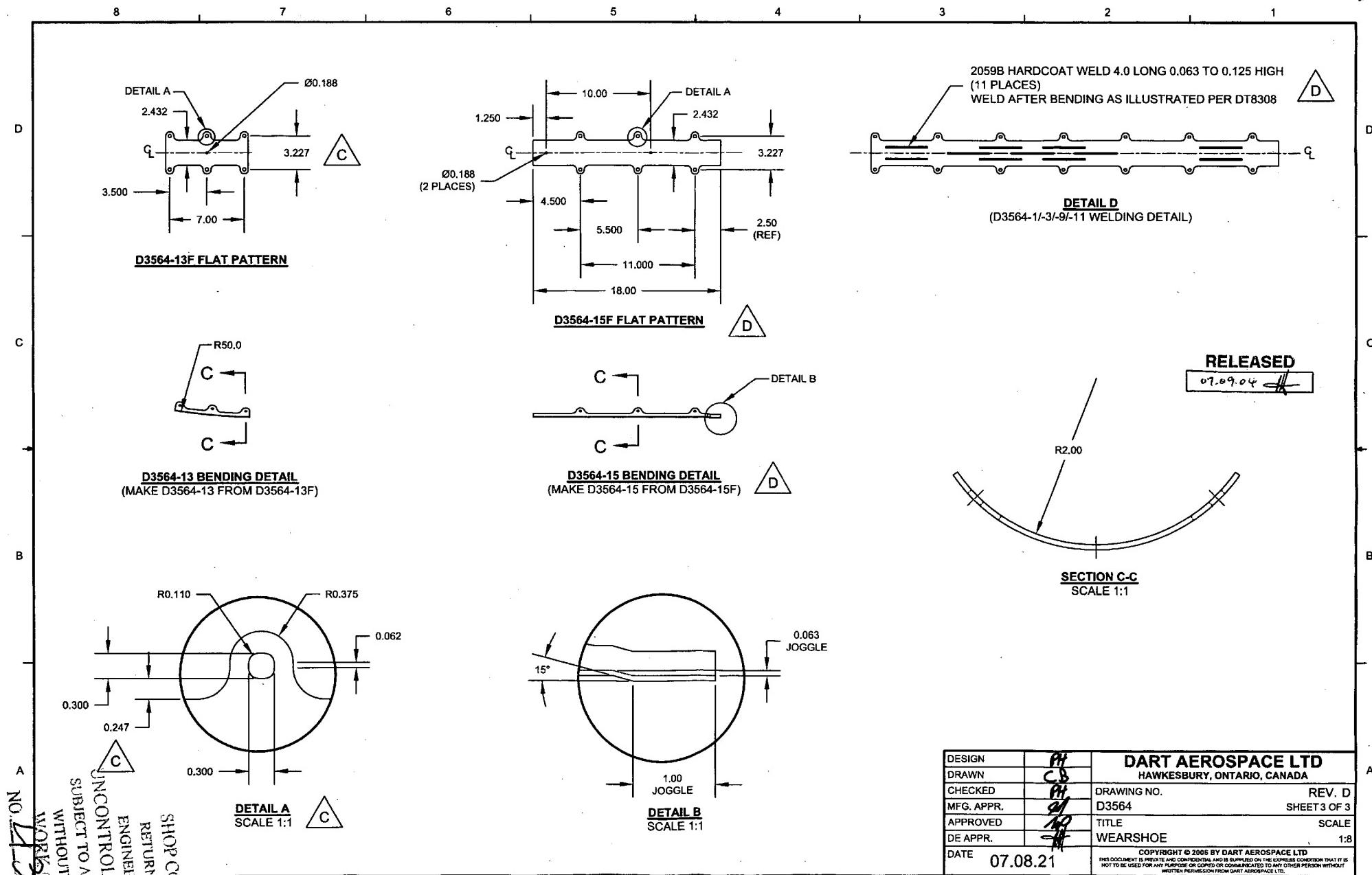


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**RELEASED**  
07.09.04

DESIGN	AH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AH	DRAWING NO.	
MFG. APPR.	SI	D3564	
APPROVED	AO	REV. D	
DE APPR.	SH	SHEET 2 OF 3	
DATE	07.08.21	TITLE	WEARSHOE

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